

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020406**Date Inspected:** 09-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector performed the following work:

Bay 14 – OBG Segment 12AW

Shielded Metal Arc Welding (SMAW) in the 4G position of PP112 Floor beam bottom flange weld # FB3081-001-164. The welder is identified as 067589. ZPMC Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. See attached photograph Pic\_001.

Bay 14 – OBG 13CW Su Assy

Sub Arc Welding (SAW) in the 1G position of 13CW sub assy plate BP3065A to BP3066A splice weld # SEG3015A-006. The welder is identified as 045270. ZPMC Quality Control (QC) is identified as Guoxing Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2. See attached photograph Pic\_002.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

### Bay 14 – OBG Segment 12CW

During in process visual inspection this QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on Cross Beam side Lifting Bracket.

### Bay 14 – OBG Segment 12CW

Flux Core Arc Welding (FCAW) in the 2G position of Counterweight side Lifting Bracket weld # SEG3006M-226.

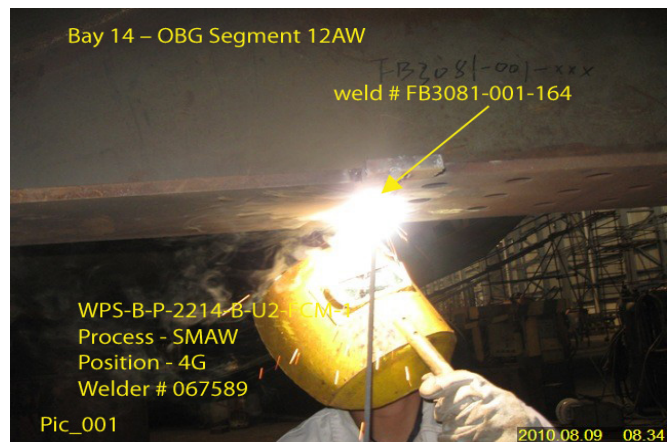
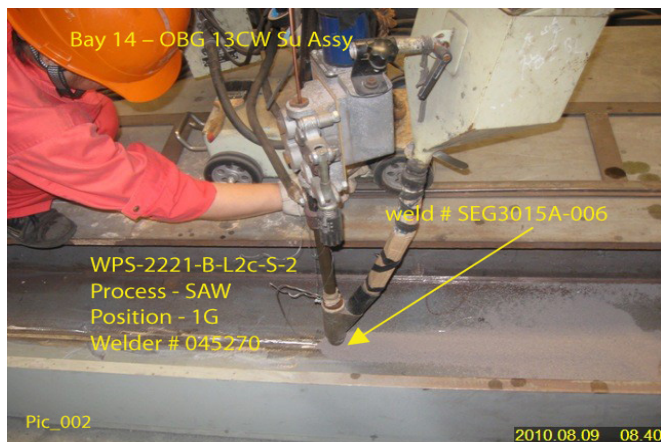
The welders are identified as 201215. ZPMC Quality Control (QC) is identified as LI ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-TC-u4b-F.

### Bay 15 – Cross Beam CB17

Shielded Metal Arc Welding (SMAW) in the 2G position of floor beam flange weld # FB3057-056-069. The welder is identified as 054460. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-B-U2-FCM-1.

### West Tower Lift 2 – Blast shop 1

This QA inspector performed Visual Inspection of West Tower Lift 2 external skin A, B, C, D, and E after Blasting.



### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

**Inspected By:** Gade,Ramesh

Quality Assurance Inspector

**Reviewed By:** McClendon,Timothy

QA Reviewer